

Date: Tuesday, 07/04/2009 1:04:43 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY
 Job Number : 46861
 Estimate Number : 11744
 P.O. Number :
 This Issue : 07/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 02/04/2009 Type : MACHINED PARTS
 Previous Run : 42232
 Written By : JP 09-04-07
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-01-06 JLM

Part Number : D3394041
 Drawing Number : D3394 R4EV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 24/04/2009 Qty: 60 Um: Each

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0735 f(s)/Unit Total : 4.4100 f(s)

D2423 Lug Extrusion

Batch: 144529

JP 09/04/07

(60)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blank to .850"

JP 09/04/07

(60)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA808 Rev: A & Dwg D3394 Rev: A

2-Deburr per dwg D3394

JP 09/04/09 (59)

N.A. 09/04/07

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A. 09/04/07

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JP 09/04/09 (59)

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Drawing Name: LUG ASSEMBLY

Job Number: 46861

Part Number: D3394041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(59)

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FL 09/04/13

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

110939

(59)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320
9:30

BL 09-04-13

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-15

(X59)

9.0 MS3548993 GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS35489-93 Grommet

M 1109185 18X M 111424 18X

1-9/16/15 (982)

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3394

EP 09/04/16

(59)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/16

center (X59)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

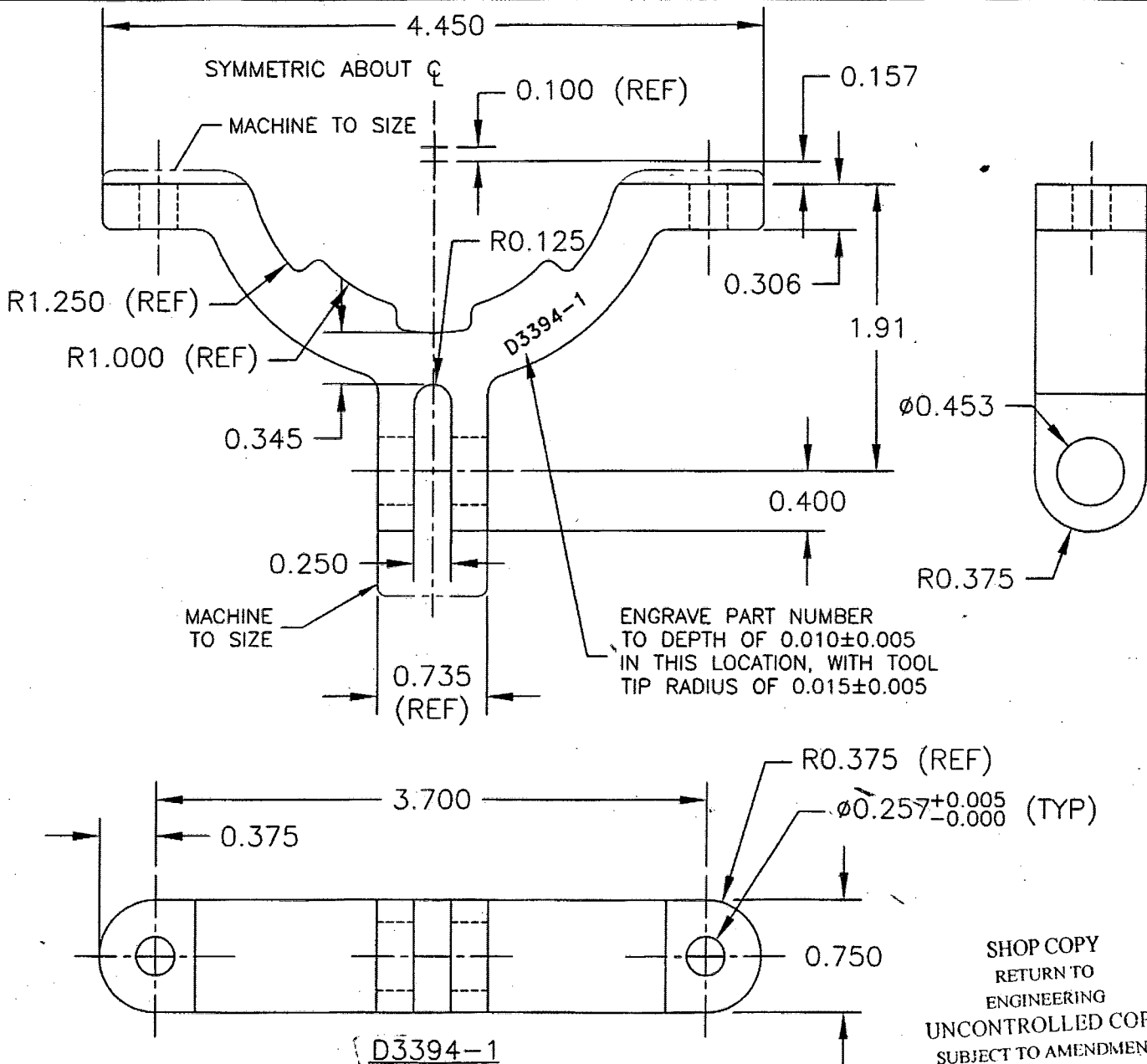
Location:

ST 474

S 09/04/20 (X59)

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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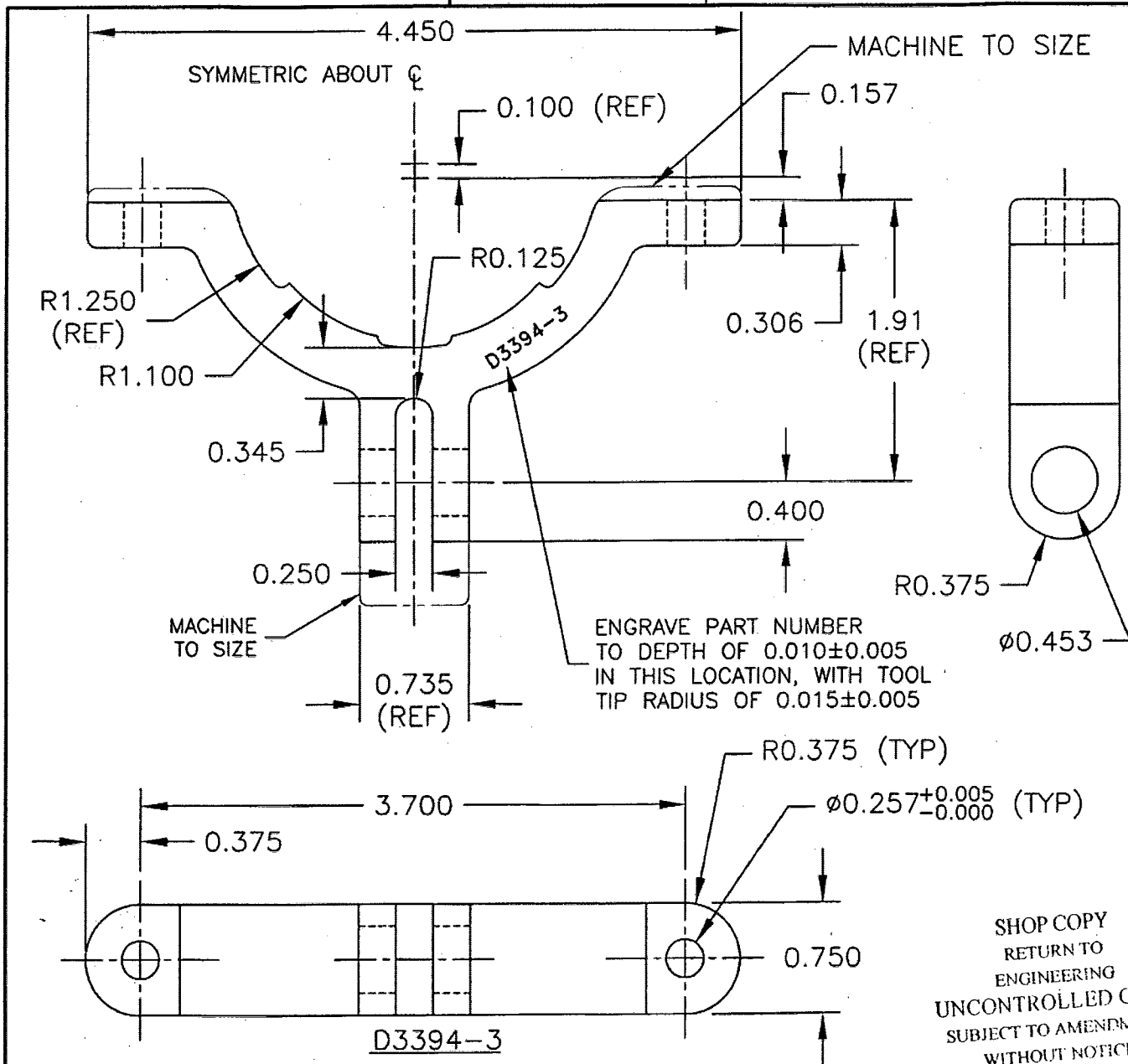
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				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 3 OF 3
				D3394	
DATE	05.02.14	TITLE	LUG	SCALE	1:1



D3394-3 NOTES

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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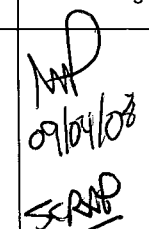
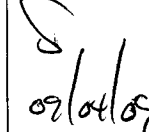
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/07	3.0	1 part scrap Chamfer tool too deep offset error by operator RC operator error	 09/04/07	scrap and no replace	H.A 09/04/07	 09/04/07	 09/04/07 SCRAP	 09/04/07

NOTE: Date & initial all entries